

Dawnprene TPE 4502-PB

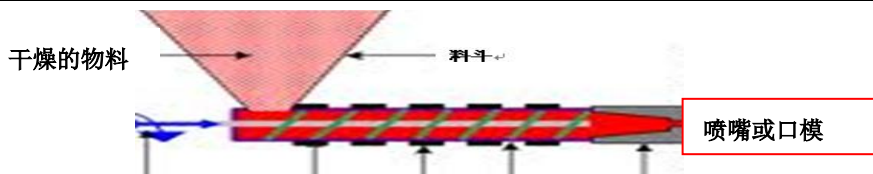
产品介绍

本材料是一种本色的 TPE 材料。拥有好的物理机械性能，好的耐化学性能及弹性，主要用于注塑。这个牌号的 TPE 可以像热塑性材料加工设备一样进行注塑成型。它可完全回收再利用。

Features:

It is a natural, thermoplastic elastomer (TPE) material. This material combines good physical properties, chemical resistance and elasticity, designed for injection applications. This grade of TPE can be processed on conventional thermoplastics equipment for injection. It is completely recyclable.

常规(GENERAL)			
应用(Application)	* 注塑制品 general injection		
RoHS Compliance	* RoHS		
颜色(Color)	* 本色 (Natural)		
形状(Form)	* 粒子 (Pellet)		
成型方法(Processing Method)	* 注塑 (injection)		
修订时期(Revision Date)	* 2020-10-11		
物理 Physical	典型值 Typical Value	单位 Unit	测试依据 Test Method
密度(Density)	0.89	g/cm ³	ASTM D792
硬度(Hardness)			
邵氏硬度 Shore Hardness(Shore A, 10 sec, 23°C)	37	A	ASTM D2240
力学性能			
拉伸强度- 平行流向 23°C Tensile strength-parallel flow direction 23°C	6.0	MPa	ASTM D412
断裂伸长率-平行流向 23°C Elongation at break-parallel flow direction 23°C	800	%	ASTM D412
100%定伸强度-平行流向 23°C 100% Steching strength-parallel flow direction 23°C	0.7	MPa	ASTM D412
300%定伸强度-平行流向 23°C 300% Steching strength-parallel flow direction 23°C	1.3	MPa	ASTM D412
撕裂强度- 垂直流向 23°C Tear strength-vertical flow direction 23°C	19	KN/m	ASTM D624
成型方法			
干燥说明：在成型之前需要对粒子进行干燥，水分过大会导致材料外观不良、机械性能下降及制品表面外观差。水分含量要求小于 0.1%，建议如下工艺干燥： Drying Instructions: Need drying the granules before make molding, excessive moisture will lead materials bad extrusion surface, mechanical performance reduction and bad surface appearance. Moisture content request below 0.1%, suggesting drying as follow process:			
干燥条件 Drying conditions	干燥温度 Drying temperature/°C	干燥时间 Drying time/h	
首选 first choice	80~90	2~3	
可选 other choice	100	1	
在 110°C 以上温度进行干燥，可能会使材料在料筒处结块；若使用水份分析仪，其温度应设定在 105°C，此材料在生产时间较短的情况下，可以不用烘干直接使用，但开口后建议烘干使用。 If drying temperature over than 110°C, it might cause materials blocking in barrel zone; if use moisture analysis meter, the temperature setting should be on 105°C.			



螺杆转速 R	一区	二区	三区	四区	五区	喷嘴或口模	模具
40-150	160-170	170-190	180-210	180-210	180-200	180-190	50-70

附加信息

1. Dawnprene TPE 与 PVC 等材料不相容，因此使用前必须清理设备

Dawnprene TPE is incompatible with PVC materials, hence must clean the equipment before using.

2. 上述测试数据是采用注塑试片，尺寸为 120 mm × 100 mm × 2 mm, 裁制而成.

Above testing data is tested by injection sample block, cutting by the sheet size is 120mm × 100 mm × 2 mm .

3. 性能为典型性能，不作为技术指标或协议.

The properties is typical performance, is not regarding as technical index or agreement.

4. 回料在使用前必须按上述操作方法执行，并确保无杂质.

Any reprocessing must follow the above instructions, and ensure no content impurity.

5. 以上工艺仅供参考，注塑机不同工艺参数也不同，请根据模具与制品形状具体调整

Above instructions for reference only, different equipment might have difference parameters, please adjust accordingly with different mold and product shape.

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